

Work Order ID 79533

79533

Page 1

January-27-12 10:01:10 AM

Item ID: D4491-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hinge, Right Upper
 Start Date: 27/01/2012 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 03/02/2012 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/01/27 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4491	A								

100 0.00
100
 Bandsaw Memo 0.00
 Jeaspa Bandsaw CUT BLANK 5.7" LONG

110 0.00
110
 Purchasing Memo 0.00
 Purchasing ISSUE P/O: 16016
 TO ARCHUR PRECISION(GLOBUS)
 C OF C IS REQUIRED

115 0.00
 Receive & Inspect CH
 QC6- Inspect dimensions to drawing
120
 QC Memo 0.00
 Quality Control

Paul 12/01/28

3

CL 12/01/27 3
6443/22 (3)

5.12/03/30

(x3)
Paul

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79533***79533***

Page 2

January-27-12 10:01:10 AM

Item ID: D4491-2 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Hinge, Right Upper
Start Date: 27/01/2012 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 03/02/2012 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location	0.00							
200									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

ST 139E

③ \$ 12-03-30

12/4/2

U 12.03.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-27-12 10:01:14 AM

Page 1

Work Order ID: 79533

79533

Parent Item: D4491-2

D4491-2

Parent Item Name: Hinge, Right Upper

Start Date: 27/01/2012

Required Date: 03/02/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A NEW ISSUE 12-01-27 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4491-2P		Purchased	No				Each	0.0000		3			
D4491-2P									**				
Hinge, Right Upper													
M304B3.500X03.500		Purchased	No				f	8.0000		9.157895			
M304B3 500X03 500									**				
304 BAR 3.500" X 3.500"													

Location

MAT009

120006

Loc Qty

8

8

Loc Code

12-03-27 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

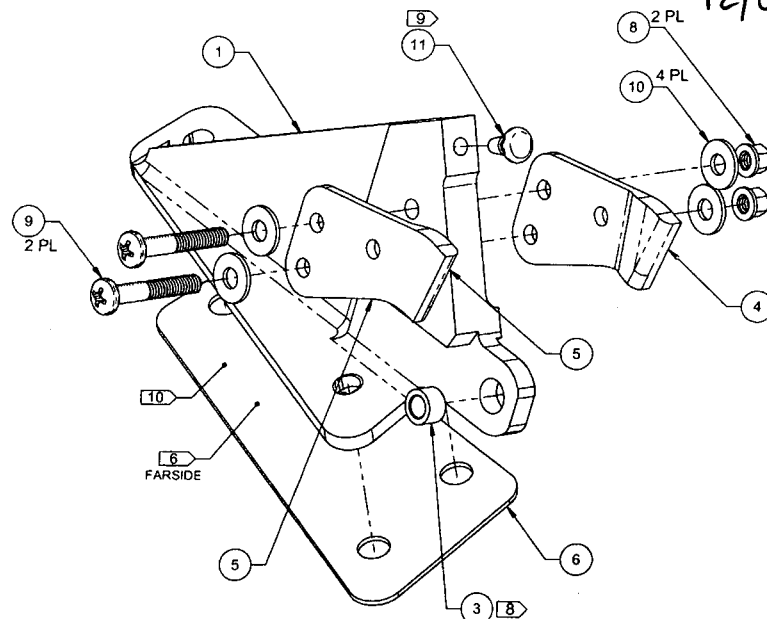
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

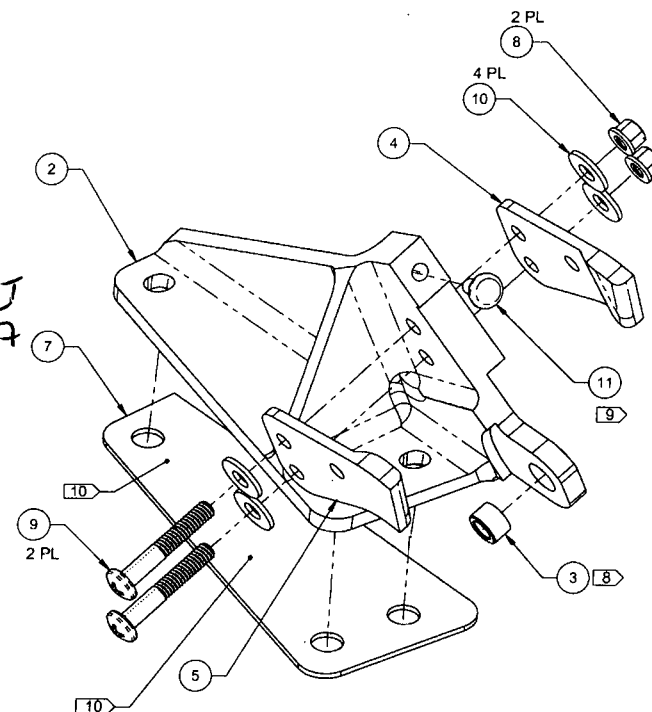
NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X	X	D4491-041	DOOR HINGE ASSY, LEFT-UPPER
			D4491-043	DOOR HINGE ASSY, LEFT-LOWER
1	1		D4491-1	HINGE, LEFT-UPPER
2		1	D4491-3	HINGE, LEFT-LOWER
3	1	1	D4492-1	BUSHING
4	1	1	D4493-1	HINGE FORK
5	1	1	D4493-2	HINGE FORK
6	1		D4520-1	HINGE SHIM
7		1	D4520-3	HINGE SHIM
8	2	2	MS21043-08	NUT, SELF LOCKING, #8
9	2	2	MS27039C0816	SCREW, PN-HD, #8
10	4	4	NAS1149CN832R	WASHER, FL, #8
11	1	1	POF-40022	PUSH-ON FEET

SHOPEX
KINGSTON
FAC 1000
UNCONTROLLED COPY
SUBMITTED FOR IDENT
WITH NO DATE
V. 1.0
NO - 79533 M.C.J
12/01/27



D4491-041 HINGE, LEFT-UPPER



D4491-043 HINGE, LEFT-LOWER

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI044 6.1
- 7) WEIGHT: 0.3 lbs
- 8) PRESS-FIT BUSHING INTO ITEM 1/2
- 9) SECURE USING 1357 CONTACT CEMENT (3M)
- 10) COAT MATING SURFACES WITH PROSEAL

RELEASE
2012-01-26

A	NEW RELEASE	RP	12.01.23
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	AS	D4491	SHEET 1 OF 6
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	DOOR HINGE SETS	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

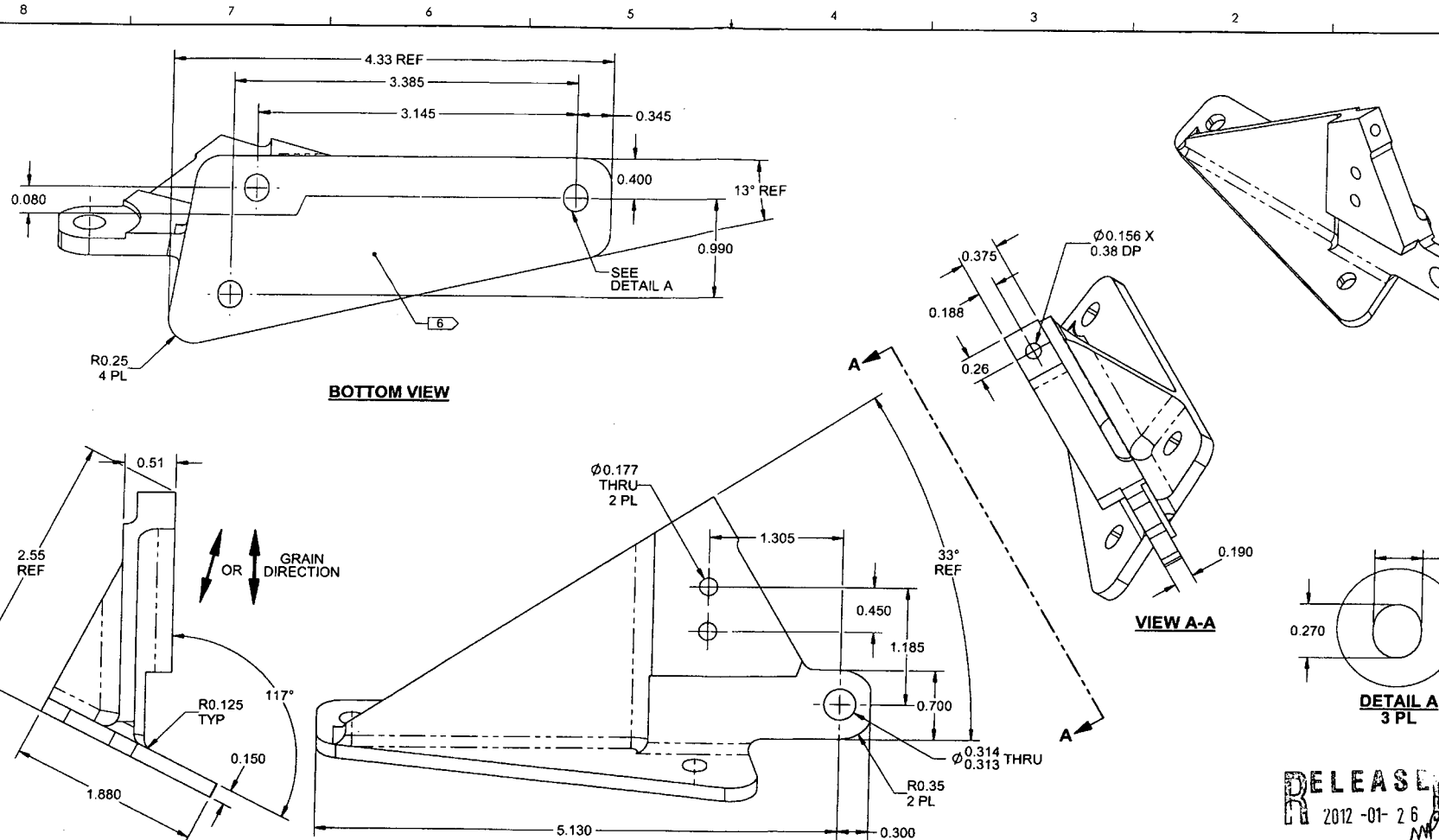
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79533



- NOTES:**
- 1) MATERIAL: AISI 303 SS BAR PER ASTM A582
REF DART SPEC M303B OR
AISI 304/316 SS BAR OR PLATE
PER ASTM A276 OR ASTM A240
REF DART SPEC M304B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI044 6.1
 - 7) WEIGHT: 0.61 lbs
 - 8) PROFILE PER DRAWING FILE "D4491-1-REVA.STP"

D4491-1 HINGE, LEFT-UPPER

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.		D4491	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		DOOR HINGE SETS	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval. QC Inspector

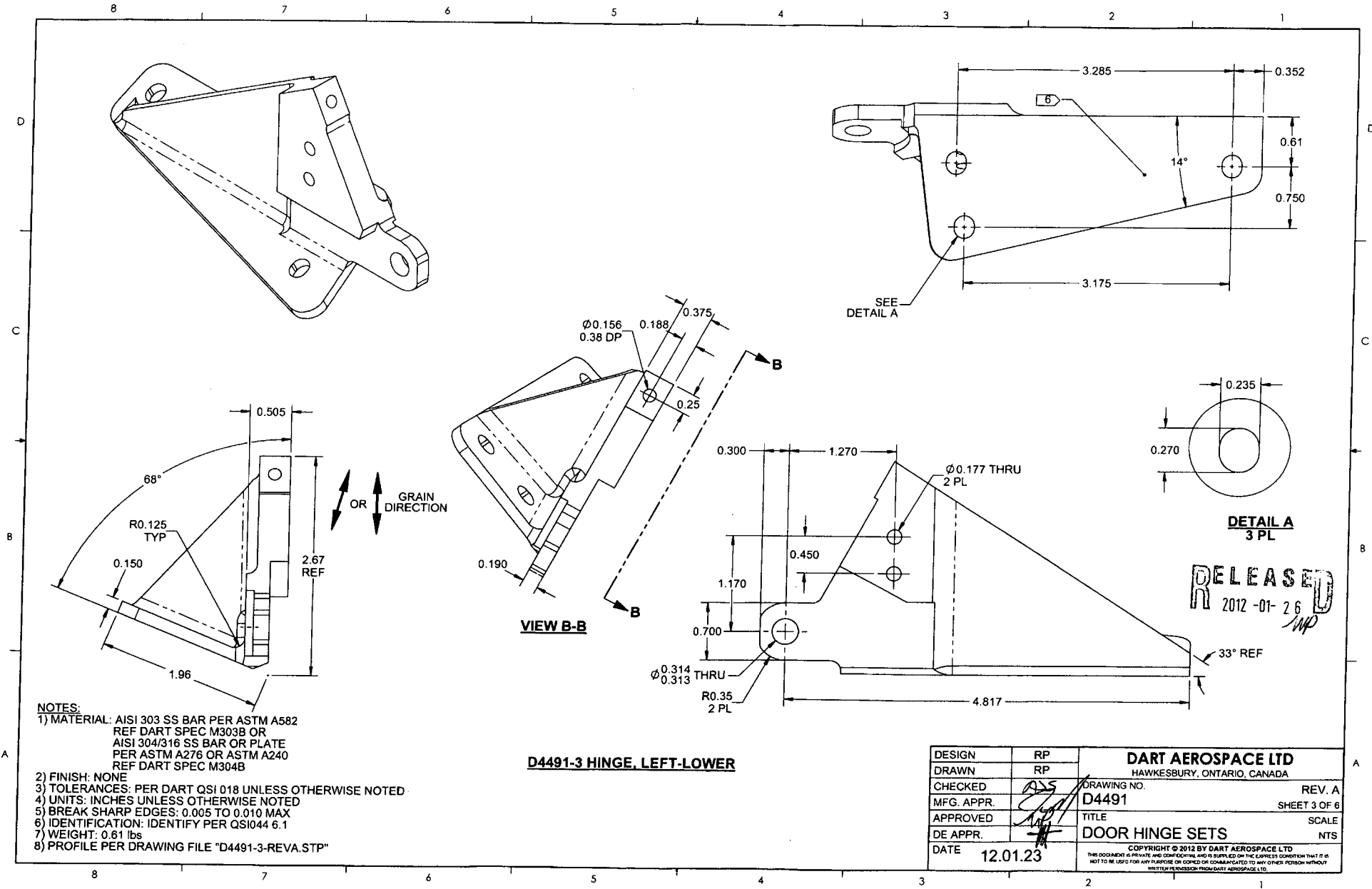
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79533



- NOTES:
- 1) MATERIAL: AISI 303 SS BAR PER ASTM A582
REF DART SPEC M303B OR
AISI 304/316 SS BAR OR PLATE
PER ASTM A276 OR ASTM A240
REF DART SPEC M304B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI044 6.1
 - 7) WEIGHT: 0.61 lbs
 - 8) PROFILE PER DRAWING FILE "D4491-3-REVA.STP"

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.		D4491	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		DOOR HINGE SETS	NTS
DATE	12.01.23	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

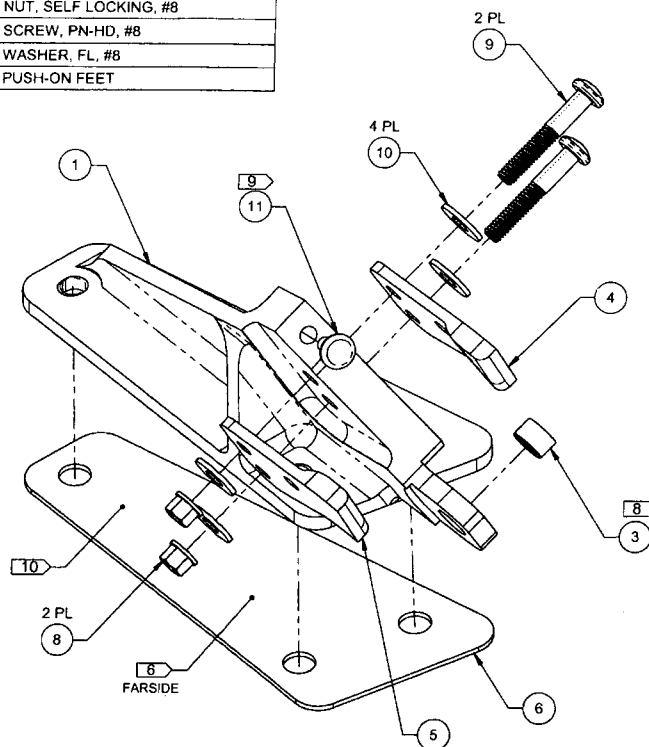
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

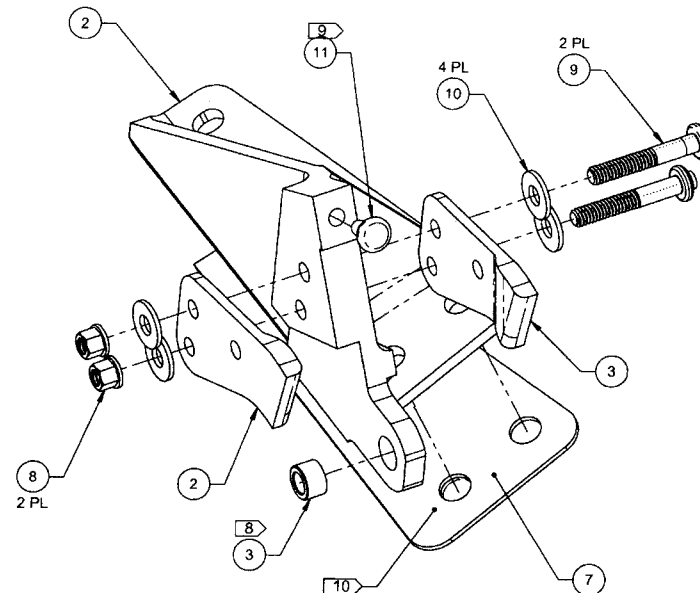
NOTE: Date & initial all entries

79533

ITEM	QTY -042	QTY -044	P/N	DESCRIPTION
	X		D4491-042	DOOR HINGE ASSY, RIGHT-UPPER
		X	D4491-044	DOOR HINGE ASSY, RIGHT-LOWER
1	1		D4491-2	HINGE, RIGHT-UPPER
2		1	D4491-4	HINGE, RIGHT-LOWER
3	1	1	D4492-1	BUSHING
4	1	1	D4493-1	HINGE FORK
5	1	1	D4493-2	HINGE FORK
6	1		D4520-1	HINGE SHIM
7		1	D4520-3	HINGE SHIM
8	2	2	MS21043-08	NUT, SELF LOCKING, #8
9	2	2	MS27039C0816	SCREW, PN-HD, #8
10	4	4	NAS1149CN832R	WASHER, FL, #8
11	1	1	POF-40022	PUSH-ON FEET



D4491-042 HINGE, RIGHT-UPPER



D4491-044 HINGE, RIGHT-LOWER

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI044 6.1
- 7) WEIGHT: 0.3 lbs
- 8) PRESS-FIT BUSHING INTO ITEM 1/2
- 9) SECURE USING 1357 CONTACT CEMENT (3M)
- 10) COAT MATING SURFACES WITH PROSEAL

RELEASED
2012-01-26

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4491	REV. A
MFG. APPR.			SHEET 4 OF 6
APPROVED		TITLE DOOR HINGE SETS	SCALE NTS
DE APPR.			
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

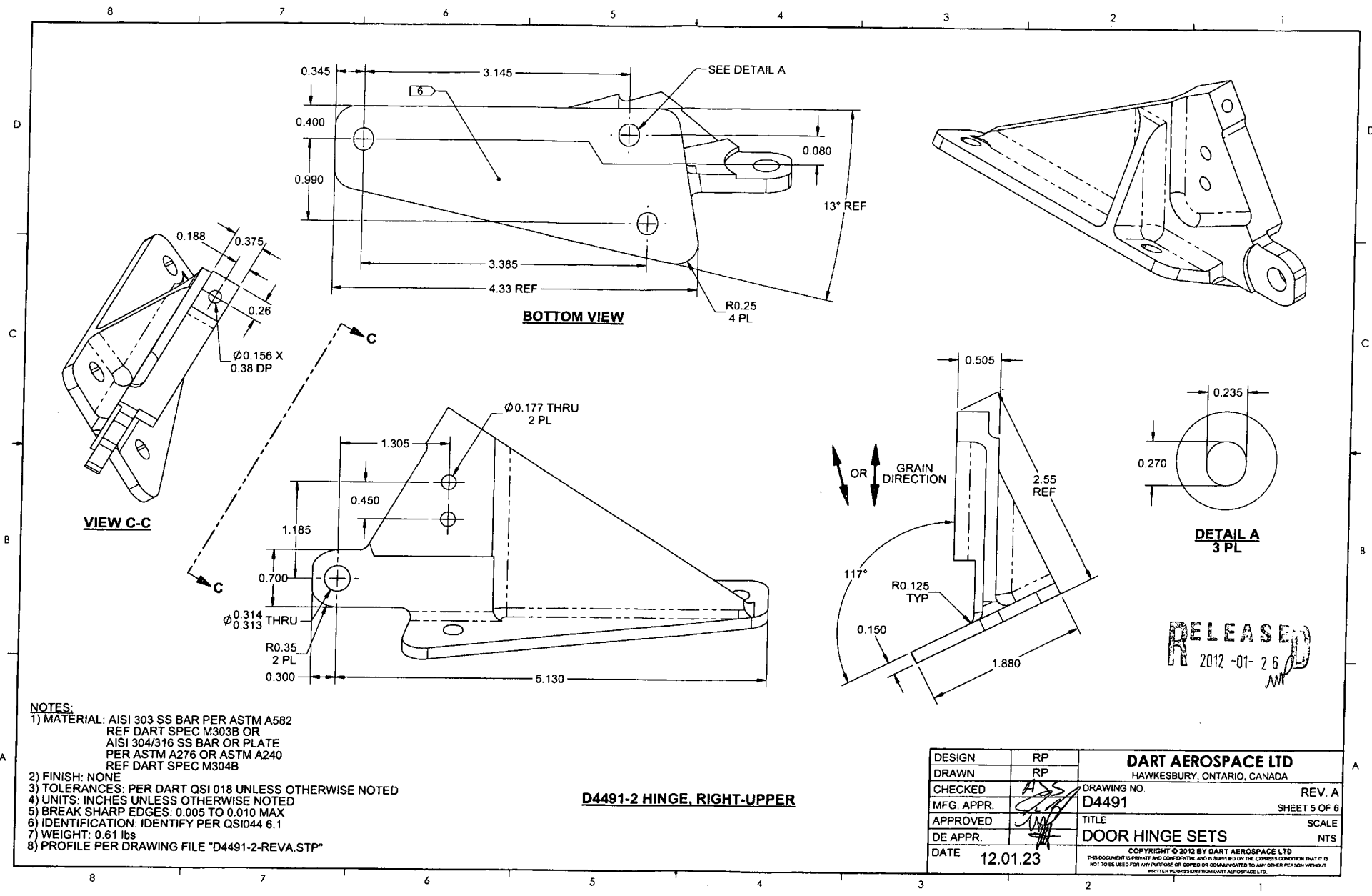
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79533



- NOTES:**
- 1) MATERIAL: AISI 303 SS BAR PER ASTM A582
REF DART SPEC M303B OR
AISI 304/316 SS BAR OR PLATE
PER ASTM A276 OR ASTM A240
REF DART SPEC M304B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI044 6.1
 - 7) WEIGHT: 0.61 lbs
 - 8) PROFILE PER DRAWING FILE "D4491-2-REVA.STP"

D4491-2 HINGE, RIGHT-UPPER

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	SA	D4491	SHEET 5 OF 6
APPROVED	SA	TITLE	SCALE
DE APPR.	SA	DOOR HINGE SETS	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

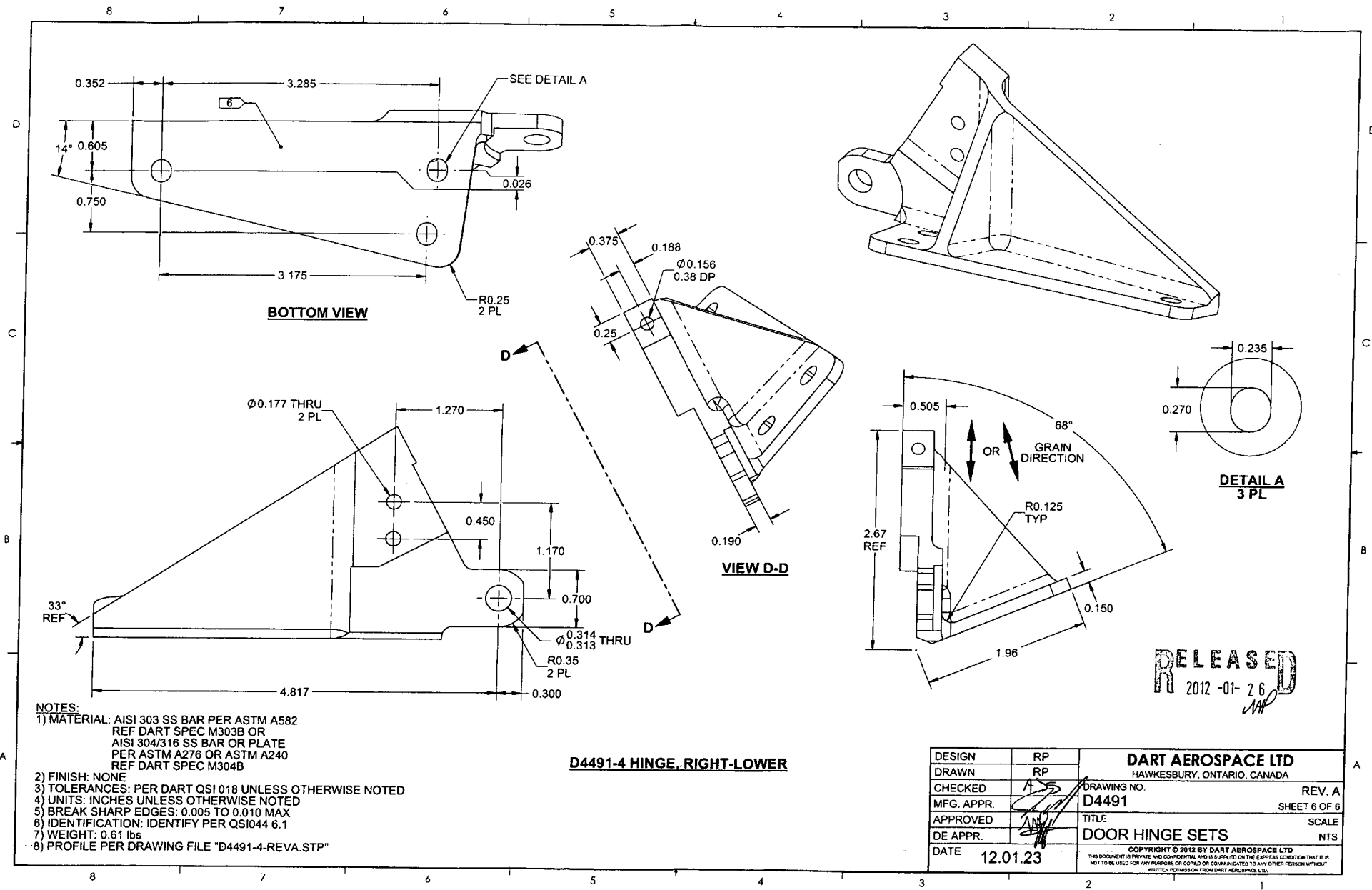
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79533



BOTTOM VIEW

VIEW D-D

**DETAIL A
3 PL**

- NOTES:**
- 1) MATERIAL: AISI 303 SS BAR PER ASTM A582
REF DART SPEC M303B OR
AISI 304/316 SS BAR OR PLATE
PER ASTM A276 OR ASTM A240
REF DART SPEC M304B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI044 6.1
 - 7) WEIGHT: 0.61 lbs
 - 8) PROFILE PER DRAWING FILE "D4491-4-REVA.STP"

D4491-4 HINGE, RIGHT-LOWER

RELEASED
2012-01-26
MHP

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.		D4491	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		DOOR HINGE SETS	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



1393 Major Road
Orleans, ON
K1E 1H3

Phone # 613-899-2405

Packing Slip

Date	Invoice #
3/26/2012	89

Ship To
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. No.	Ship	Via	FOB	Project
16016	3/26/2012	FedEx	Archer	

Qty	Item Code	Description
3	Sales	D4491-1
3	Sales	D4491-2
1	Sales	D4491-3
2	Sales	D4491-4
		HST (ON) on sales



1393 Major Road
Orleans, Ontario
K1E 1H3


Telephone (613) 899-2405
Fax (613) 226-1719

Certificate of Compliance

To:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury Ont.
K6A 1K7

Po Number	Part Number	Quantities
16016	D4491-1	3
	D4491-2	3
	D4491-3	1
	D4491-4	2

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 16016 issued by Dart Aerospace Inc.



Alex Mazerolle
President
Archer Precision Inc.
1393 Major Road,
Orleans Ontario
K1E 1H3